

Date: Thursday, 17/07/2008 1:23:52 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40594
 Estimate Number : 13425
 P.O. Number :
 This Issue : 17/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 14 Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By : mf 08-07-#17
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : SQUARE TUBE
 Part Number : PB6743001203
 Drawing Number : B6743001 P.17
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 24/07/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W005 120	6061T6 SQ TUBE 1.00 x 1.00 X 0.065w

Comment: Qty.: 1.6844 f(s)/Unit Total: 16.8441 f(s)
 6061T6 SQ TUBE 1.00 X 0.065
 batch: H108626



SAD 08/07/17 (10)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.050" chamfer on both ends of tube
- 3- deburr



SAD 08/07/17 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP



SAD 08/07/17 (10)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1- drill holes as per dwg
 2- make a 0.050" chamfer (100 degree) on both side of the 2 holes
 3- deburr



SAD 08-07-30 (10)

SAD 08/07/17 (10)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP



SAD 08/07/28 (10)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 40594

Part Number: PB6743001203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001227

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

batch:

340273

08-07-29
08-07-29

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

08-07-29 (10X)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

08-07-29 (10X)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/4/09 (10X)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/4/09 (10X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT E

08/08/26

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

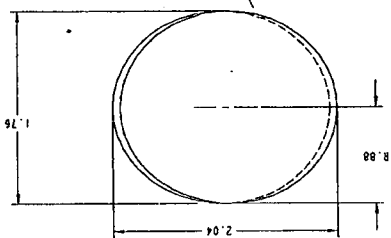
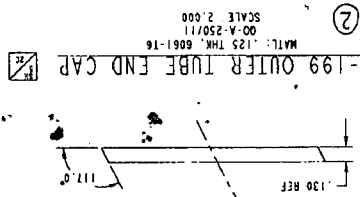
Job Completion



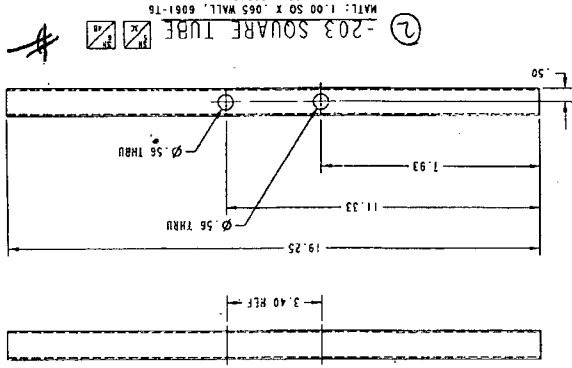
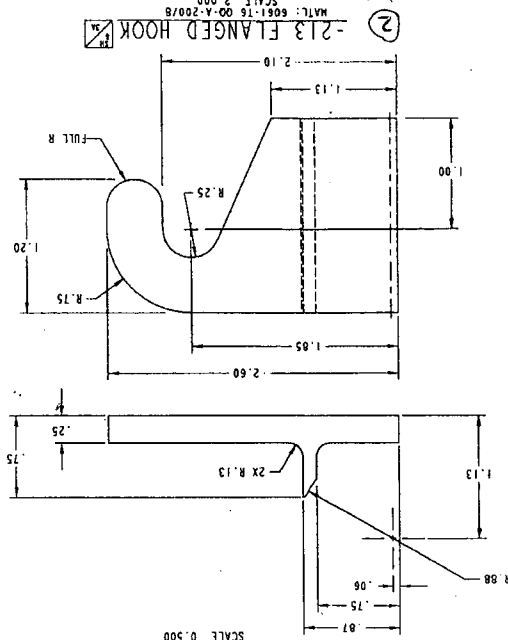
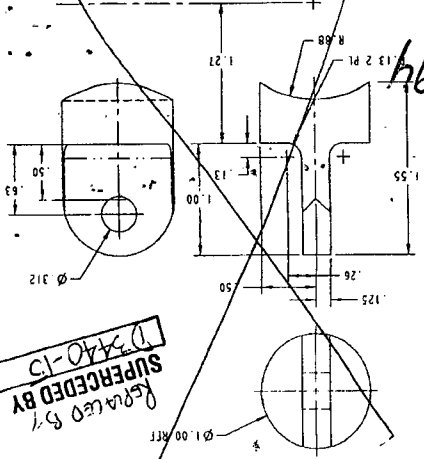
MF 08-08-26

ORIGINAL

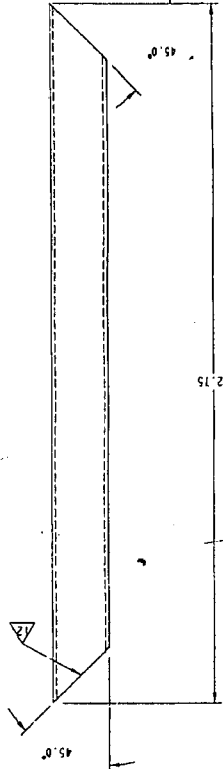
PREMIER AVIATION, INC.
8000 Aviation Parkway, Grand Prairie, Texas 75052
D:\OSUVR\B67-43001
SCALE 1:1
DATE 11-0-83



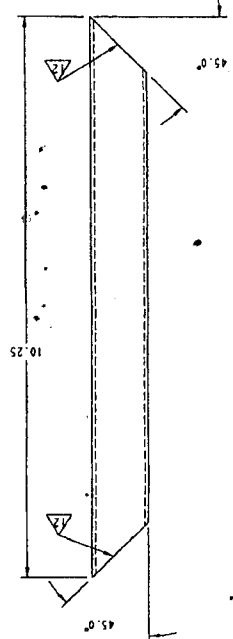
①
-215 CONTOURED MALE EYE
MATERIAL: 1.00 RND, 6061-T6
SCALE 2:000



④2
-211 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL, 6061-T6
SCALE 1:000



②
-209 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL, 6061-T6
SCALE 1:000



REPLACED BY
03440-13

RELEASED

